

Work Order ID 81813

Monday, March 19, 2012 2:33:59 PM

81813*Ship Tuesday March 20*

Page 1

Item ID: D4268-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Instrument Panel (212)

Start Date: 3/19/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 3/20/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan: *MF*Date: *12-03-19*

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4268

A

100

0.00

100

Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per Dwg (D4268-3)

Dwg Rev: *A*Prog Rev: *A*

2-Deburr if necessary

0.00

*12-3-20**(6)*

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.00

12-3-20

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Item ID: D4268-3

Accept

N9000040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Instrument Panel (212)

Start Date: 3/19/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 3/20/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

SA 12/3/20

6

4

130

0.00

130

Small Fab

Memo

0.00

Small Fab

1- C'sink holes as per dwg
2- Bend as per dwg

SB 12/3/20

SB 12/3/20 @
(6)

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

SA 12/3/20

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Item ID: D4268-3 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Instrument Panel (212)
Start Date: 3/19/2012 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 3/20/2012 Req'd Qty: 6.00 ***6*** Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Chemical Conversion Coat per QSI005 4.1	0.00							
150									
HandFinish	Memo	0.00							
Hand Finishing									
160	Spray Painting per QSI005 4.2	0.00							
160									
SprayPaint	Memo	0.00							
Spray Painting	Prime per QSI 4.2 and as per dwg								
170	QC14- Inspect Spray Paint	0.00							
170									
QC	Memo	0.00							
Quality Control									

246 - 12-3-19AA 12 - 3 - 20EE 12 - 03 - 21

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Item ID: D4268-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Instrument Panel (212)
 Start Date: 3/19/2012 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 3/20/2012 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	Identify as per dwg & Stock Location:	0.00							
200									
Packaging	Memo	0.00							
Packaging									
210	QC21- Final Inspection - Work Order Release	0.00							
210									
QC	Memo	0.00							
Quality Control									

Comp/21(6)

MLJ 12/03/21
MF
1203-21

*SHIP
ROGUE*

Picklist Print

Monday, March 19, 2012 2:33:59 PM

Page 1

Work Order ID: 81813

Parent Item: D4268-3

Parent Item Name: Instrument Panel (212)

Start Date: 3/19/2012

Required Date: 3/20/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 11.02.07 new issue DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.040 2024-T3 .040 sheet		Purchased	No			100	sf	210.1584	0.0744	0.4698947			

1812-3-20

Location

Loc Qty

Loc Code

MAT022

210.158421

117684

21.318421

120196

59.41

120605

129.43

120605

66

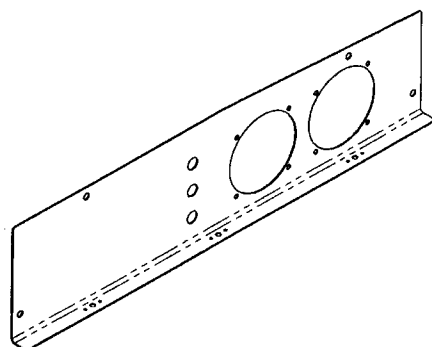
DART AEROSPACE LTD		Work Order: 81813
Description: Instrument Panel		Part Number: D4268-3
Inspection Dwg: D4268	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

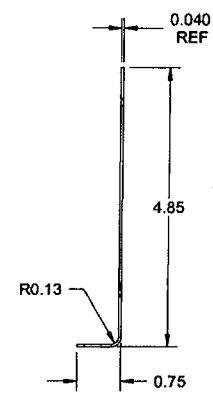
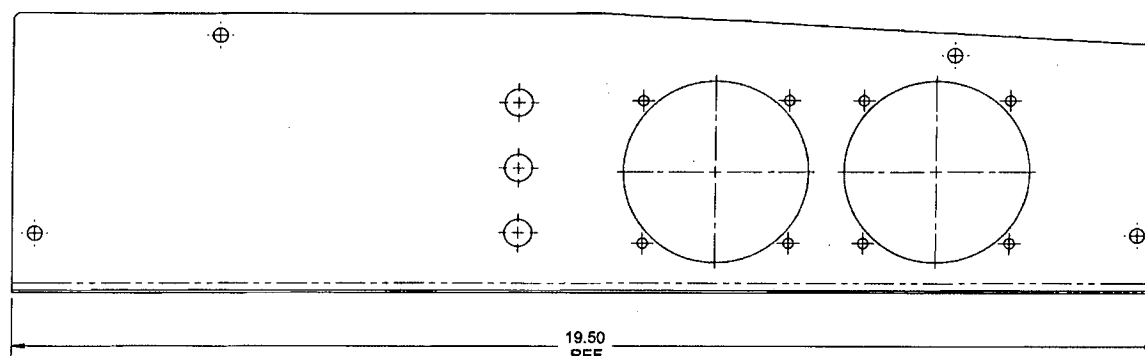
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	.100	✓		V B02	
Ø0.177	+0.005/-0.001	.179	✓		V	
Ø0.191	+0.005/-0.001	.192	✓		V	
Ø0.250	+0.005/-0.001	.250	✓		V	
Ø0.470	+0.006/-0.001	.470	✓		V	
Ø3.150	+0.012/-0.001	3.152	✓		V	
Ø3.505	+0.012/-0.001	3.506	✓		V	
4.95	+/-0.030	4.970	✓		V	
2.478	+/-0.010	2.480	✓		V	
1.239	+/-0.010	1.239	✓		V	
1.65	+/-0.030	1.649	✓		V	
2.75	+/-0.030	2.75	✓		V	
19.50	+/-0.030	19.50	✓		T B01	
12.50	+/-0.030	12.50	✓		T	
6.00	+/-0.030	6.00	✓		V	
3.50	+/-0.030	3.497	✓		V	
0.350	+/-0.010	.351	✓		V	
0.344	+/-0.010	.344	✓		V	
0.688	+/-0.010	.680	✓		V	
1.69	+/-0.030	1.693	✓		V	
1.13	+/-0.030	1.133	✓		V	
2.26	+/-0.030	2.260	✓		V	
5.50	+/-0.030	5.503	✓		V	
0.38	+/-0.030	.381	✓		V	
3.50	+/-0.030	.350	✓		V	
8.60	+/-0.030	8.60	✓		T	
10.00	+/-0.030	10.00	✓		T	
3.80	+/-0.030	3.80	✓		V	
3.75	+/-0.030	3.75	✓		V	
3.50	+/-0.030	3.50	✓		V	
1.239	+/-0.010	1.240	✓		V	
0.040	+/-0.010	.041	✓		V	

Measured by: RB	Audited by: SA	Preliminary Approval:
Date: 12-3-20	Date: 12/3/20	Date:

Rev	Date	Change	Revised by	Approved
A	11.04.28	New Issue	KJ	



81813



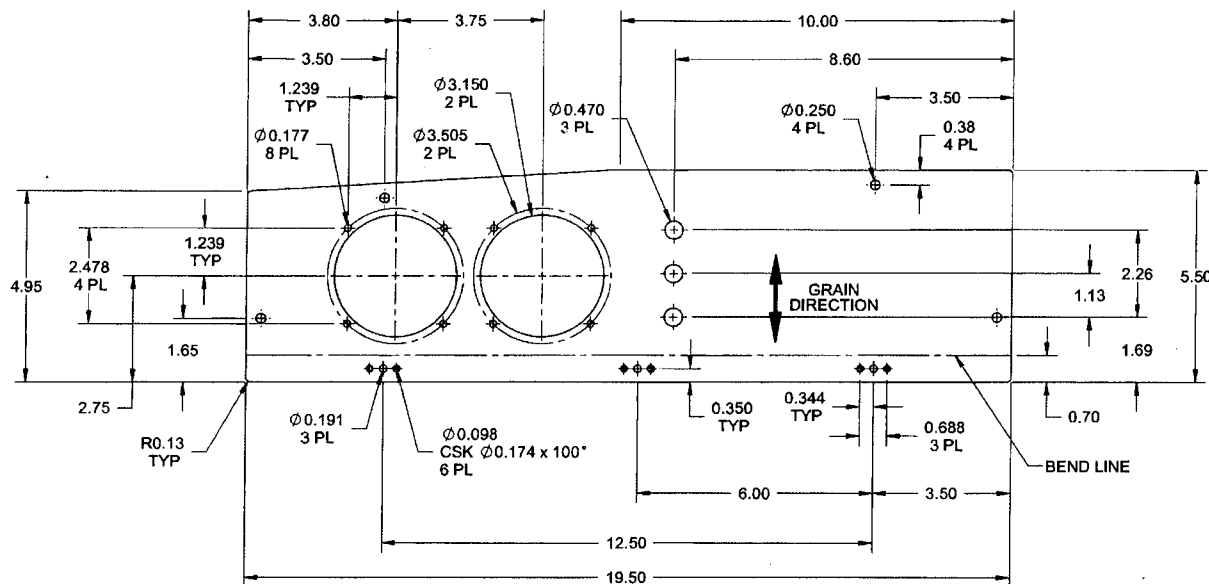
D4268-3 INSTRUMENT PANEL (212/412)
(REF. EAGLE DRAWING No. D2046902 P/N EA20469-15-412)

RELEASED
R 2011-04-06 JAW

NOTES:

- 1) MATERIAL: MAKE FROM D4268-3F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 AND PRIME PER QSI 005 4.2.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.35 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO. D4268	REV. A
MFG. APPR.	<i>[Signature]</i>	SHEET 5 OF 12	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	VRD PARTS	NTS
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D4268-3F FLAT PATTERN
(REF. EAGLE DRAWING No. D2046902 P/N EA20469-15-412)

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.040 THICK
QQ-A-250/4 OR AMS-QQ-A-250/4
OR AMS 4037
OR ASTM B209
PER DART SPEC M2024T3S.040
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.35 lbs

RELEASED
2011-04-06
NN

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO. D4268	REV. A
MFG. APPR.	<i>[Signature]</i>	SHEET 6 OF 12	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	VRD PARTS	NTS
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